

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65082

Thursday, January 06, 2011 9:52:08 AM



Page 2

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Adapter Assembly

Start Date: 1/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr 2-C'sink as per Dwg								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
141 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten: 8/5/01/13 (30)

Handwritten: 8/4/01/13

Handwritten: conto
(+30)

Handwritten: 30 0 1/10/13

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Page 3

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Adapter Assembly

Start Date: 1/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

30 BL 11-01-13.

170



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Install Nut plate as per Dwg

G. B. 11/01/13 29
30

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S. 11/01/13

COUNT
X29

Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4164-041 PAR #: _____ Fault Category: Small Fms NCR: Yes No DQA: ✓ Date: 11/01/31
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/02/02

NCR: <u>65082</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/01</u>	<u>#180</u>	<u>@ step # 180 canisters 29 pcs when there should be 30. qty +1 part lost between Alodine to small Fob.</u>	<u>[Signature]</u>	<u>Remains employee of importance at counter part At start of work on w/b.</u>	<u>[Signature]</u> <u>11/02/01</u>	<u>S</u> <u>11/02/01</u>	<u>[Signature]</u>	<u>S</u> <u>11/01/19</u>
		<u>R.L. Part lost LQA.</u> <u>D4164-1 qty - lost scrap</u>	<u>[Signature]</u>	<u>- part lost part scrap.</u> <u>no repare extans made.</u>			<u>[Signature]</u>	<u>S</u> <u>11/01/19</u>

NOTE: Date & initial all entries

Work Order ID 65082

Thursday, January 06, 2011 9:52:08 AM



Page 4

Item ID: D4164-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Adapter Assembly

Start Date: 1/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

1/11/02 (29)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1/11/02 (29)1/11-02-1 (29)

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 9:52:11 AM

Page 1

Work Order ID: 65082

Parent Item: D4164-041

Parent Item Name: Nut Plate Adapter Assembly






Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-09-07 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040  6061-T6 .040 Sheet		Purchased	No			100	sf	53.2300	0.001	0.021053	1		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT21				53.23					
					111224			2					
					113004			51.23					
MS21059L3  Nut Plate		Purchased	No				Each	24.0000	1	20			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST301				24					
					114718			6					
					116158			18					
MS20426AD3-3  Rivet		Purchased	No				Each	3,695.000	2	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				3695					
					19099			3695					

PB(-1-11

30

111224

454/01/19

M116582

300

454/01/19

60

W/O:		WORK ORDER CHANGES					
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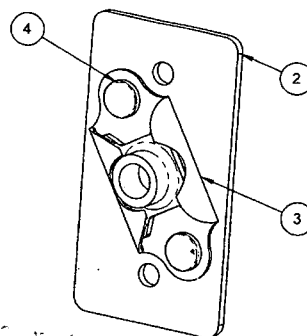
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 65082
BS11-01-6



D4164-041 NUT PLATE ADAPTER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4164-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.006 lbs

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4164-041	NUT PLATE ADAPTER ASSEMBLY
2	1	D4164-1	NUT PLATE ADAPTER
3	1	MS21059L3	NUT PLATE
4	2	MS20426AD3-3	RIVET

RELEASED
 2010-09-07
WJ

A NEW ISSUE		RF	10.07.22
REV.	DESCRIPTION		BY DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4164	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	NUT PLATE ADAPTER ASSY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

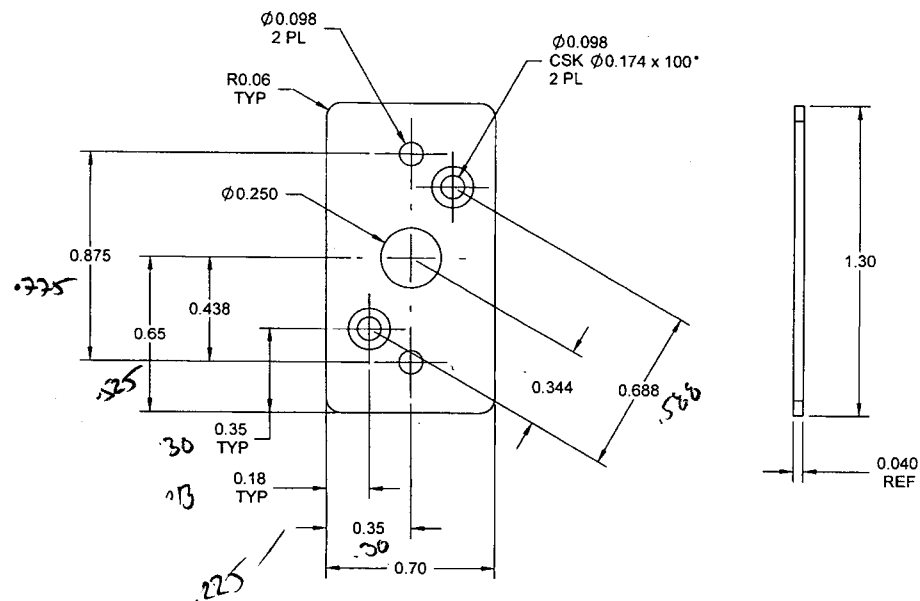
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NOTE: Date & initial all entries



D4164-1 NUT PLATE ADAPTER

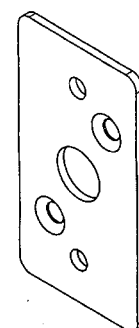
NOTES:

- 1) MATERIAL: 6061T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC. M6061T6S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	KB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4164	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		NUT PLATE ADAPTER ASSY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-09-07
JMD

w/065082



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